Work Order ID 74740

Wednesday, October 05, 2011 2:37:07 PM

Item ID: D3774-1 **Accept**

Setup Start / Stop

Revision ID:

Item Name: Seat Bottom, LH/RH

Start Date: 10/5/2011 **Start Qty:** 4.00

Required Date: 10/14/2011 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ____ **Date:** 11-10-5 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3774	**Revision Nbr** Rev B								
100 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Set up machine program D3774-1□Set up clamping frame as per folio	0.00 0.00				x4			11/10/20
110 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Cut Blanks	0.00 0.00				x4			11/10/20

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74740

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QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 HandThermo Hand Finishing Thermoforming	Dry Material **Memo** Dry Sheet as per QSI022 POLYCARBONATE Temp: 240°F Time IN: 4:00 pm Time OUT: 9:00 pm	0.00 0.00				x4			DL 11/10/20
120 Thermoform Thermoforming Machine	THERMOFORMING MACHINE **Memo** Thermoform as per Dwg. D3774-1and Folio ☐Dwg. Rev. B ☐Folio Rev. C	0.00 0.00				x4			DL 11/10/20
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				x4			DL 11/10/20

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74740

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Item Name: Seat Bottom, LH/RH

Start Date: 10/5/2011 **Start Qty:** 4.00

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Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Trim to Finished Dimensions	0.00 0.00				x 4			DTa 11/10/25
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo** 1) Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				x 4			DT 11/10/26
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 11/10/27				(+4)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74740

Wednesday, October 05, 2011 2:37:07 PM

Item ID: D3774-1 **Accept**

Setup **Start** **Stop**

Revision ID:

Item Name: Seat Bottom, LH/RH

Start Date: 10/5/2011 **Start Qty:** 4.00

Required Date: 10/14/2011 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging Packaging	Identify as per dwg & Stock Location: 257 **Memo**	0.00 0.00				11/10/27			(4)
180 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00					11/10/28		

11-10-28

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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Picklist Print

Wednesday, October 05, 2011 2:37:12 PM

Work Order ID: 74740

Parent Item: D3774-1

Parent Item Name: Seat Bottom, LH/RH

Start Date: 10/5/2011 **Required Date:** 10/14/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL IPP Rev. C
Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			110	sf	902.1763	10.667	42.668			

Location	Loc Qty	Loc Code
MAT018	902.176289	
116236	902.176289	

42.668 sq. ft.

DL 11/10/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74740
Description: Seat Bottom	**Part Number:**	**D3774-1**
Inspection Dwg: D3774 **Rev:** B		

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	11/10/20

TRIMMING SECTION

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.3	+/-0.100	1.33"	✓		VERN DL-02	
	33.9	+/-0.100	33.8"	✓		TAPE DL-01	
	17.4	+/-0.100	17.4"	✓		TAPE DL-01	
#10	0.085	Min	0.086"	✓		CAL TH-DT	
#11	0.100	Min	0.110"	✓		CAL TH-DT	
11	0.100	Min	0.109"	✓		CAL TH-DT	
11	0.100	Min	0.107"	✓		CAL TH-DT	
11	0.100	Min	0.106"	✓		CAL TH-DT	

Measured by:	DL	**Date:**	11/10/26
Audited by:	[signature]	**Date:**	11/10/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL [signature]	[signature]

Dart Aerospace Ltd

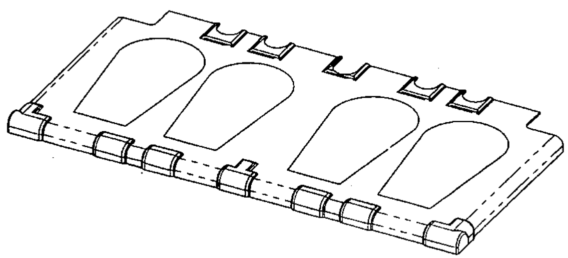
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

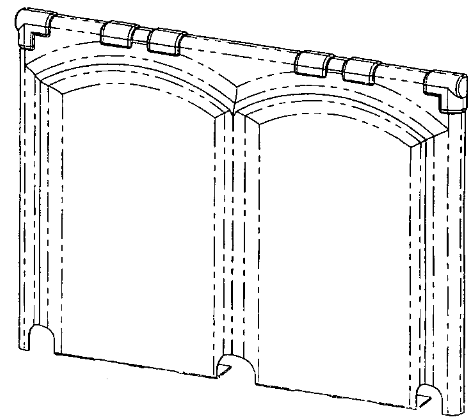
Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

RELEASED 08-08-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19740

R11-10-5

REV.	DESCRIPTION	BY	DATE
B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23

DESIGN	HS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3774 — REV. B — SHEET 1 OF 3
CHECKED		
MFG. APPR.		TITLE SEAT — SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.25	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

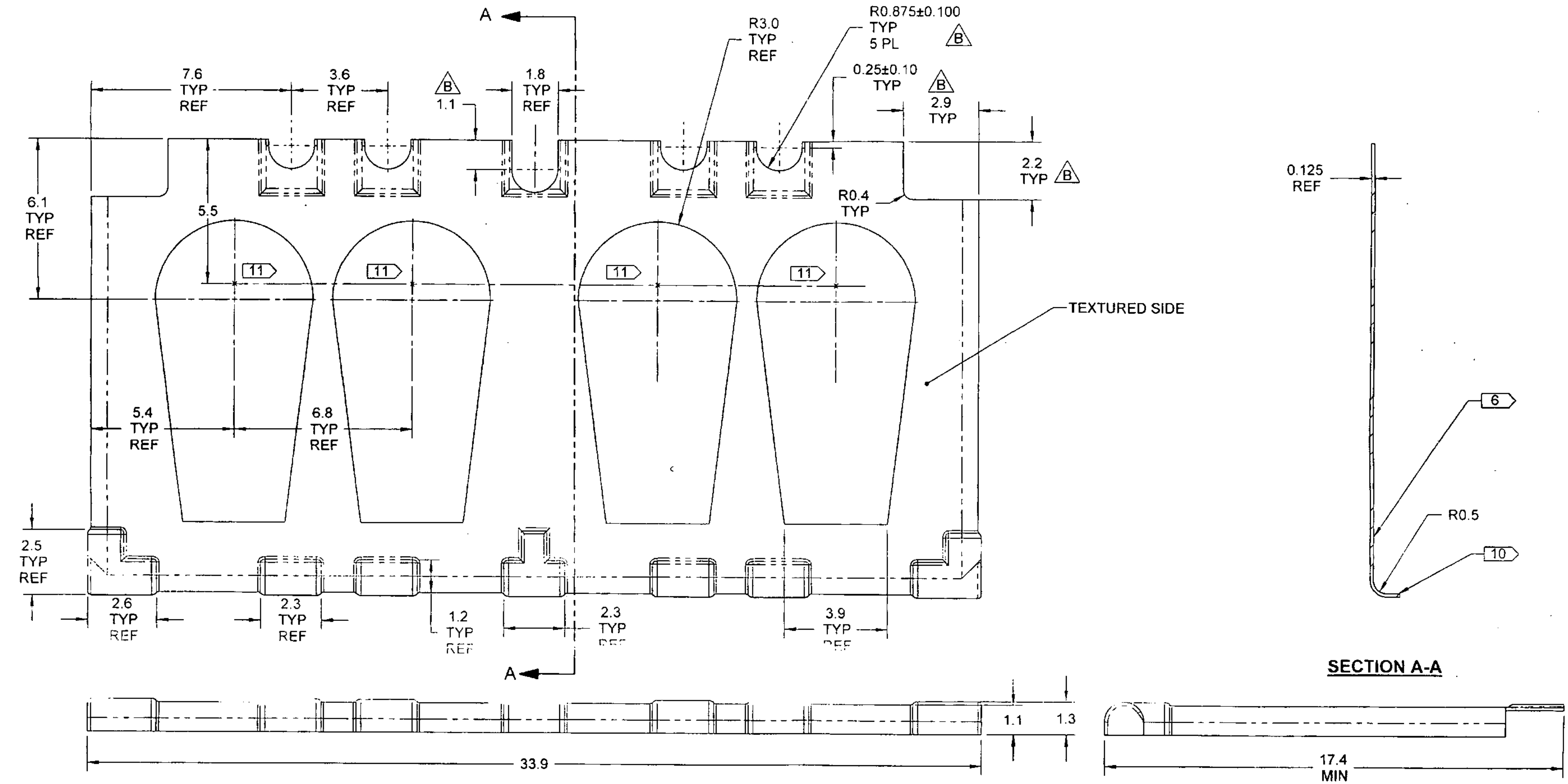
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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D3774-1 SEAT BOTTOM

14140

RELEASED 08.08.11

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
7) WEIGHT: 2.93 lbs
8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100 (B)

DESIGN	HS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3774 — REV. B — SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE SEAT — SCALE NTS
DE APPR.		
DATE	08.07.25	

Dart Aerospace Ltd

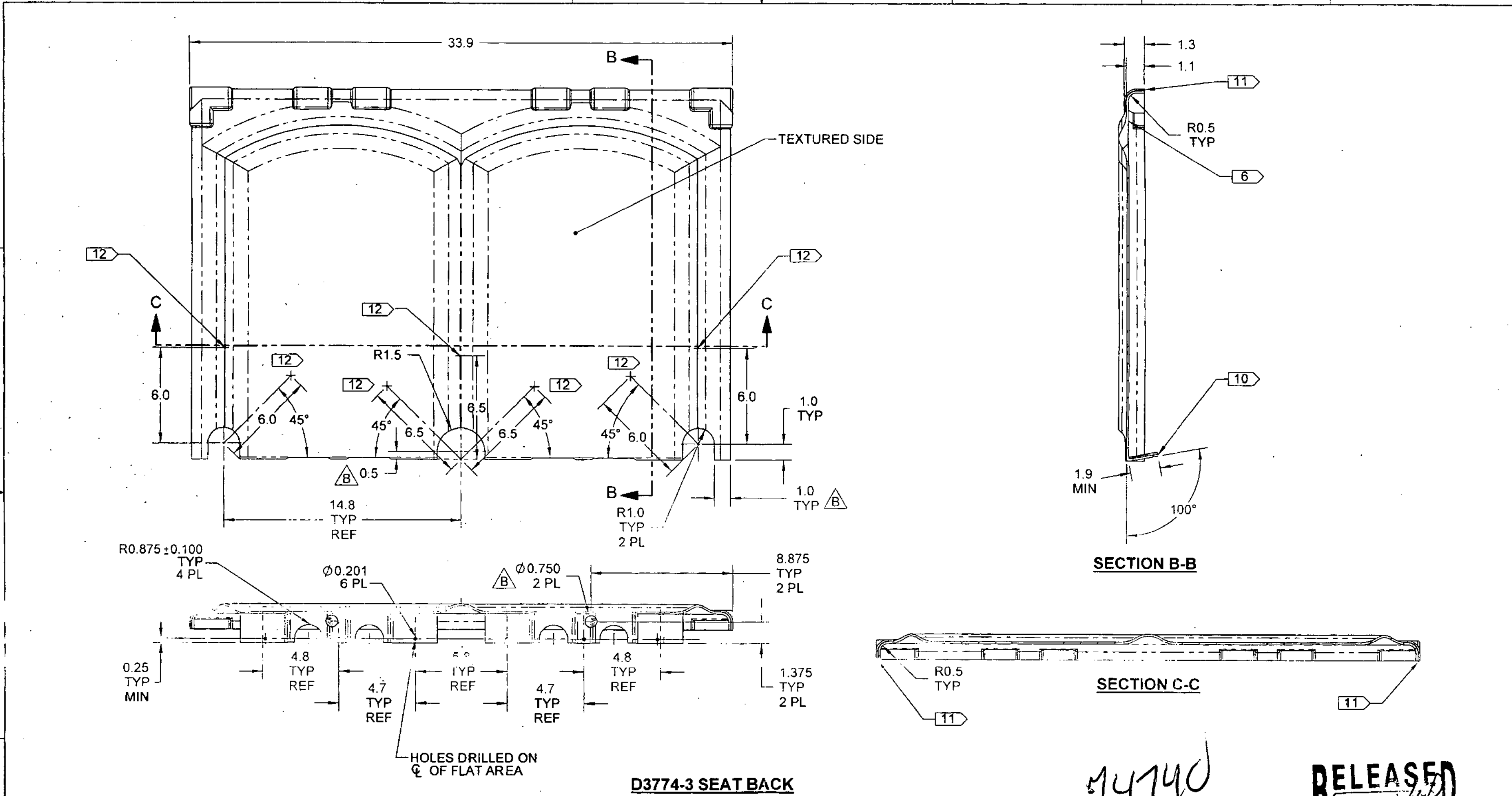
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries



NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
7) WEIGHT: 4.82 lbs
8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085 (B)
12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	[illegible]	
CHECKED	[illegible]	DRAWING NO. D3774 — REV. B — SHEET 3 OF 3
MFG. APPR.	[illegible]	
APPROVED	[illegible]	TITLE SEAT — SCALE NTS
DE APPR.	[illegible]	
DATE	08.07.25	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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